

D350-615-041

Dart Aerospace Ltd.

Date: Tuesday, 06/01/2009 10:05:10 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE ASSEMBLY		
Job Number	: 44403B			Part Number	: D2282043		
Estimate Number	: 11180			Drawing Number	: D2282 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/01/2009	S.O. No.	:	Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 31/01/2009	Qty:	50 Um: Each
Previous Run	: 44314B						
Written By	:						
Checked & Approved By	: JWD 09.01.06						
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2281	Jack Saddle	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2281	Saddle <i>B44/318</i>	
			<i>SP 09.01.22</i>
2.0	D22827	Tube	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	2 D2282-7	tube <i>B44/57=26</i>	
			<i>B44/44=74</i>
			<i>SP 09.01.22</i>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per D2282-043 Saddle Assembly	
	A/R ER316L SS	Filling Rod <i>M10x115</i>	
		Dwg Rev: <i>E</i>	
			<i>SP 09.01.27</i>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1- grind weld flush, take all welding marks out and deburr holes	
			<i>m-f 09/02/05</i>
			<i>SP 09.01.27</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/01/2009 10:05:10 AM
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Process Sheet

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Drawing Name: SADDLE ASSEMBLY

Job Number: 44403B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DS 09-02-05 (XSD)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (XSD) counter

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble HB 9-2-9

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (XSD)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 254

DS 09/02/10 (XSD)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11 DS

Job Completion



MR
09-02-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

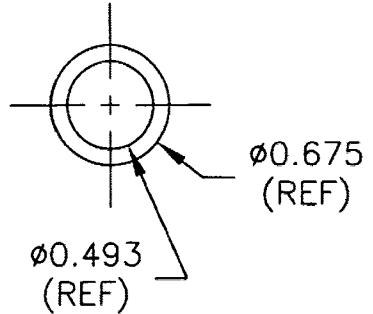
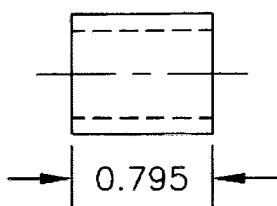
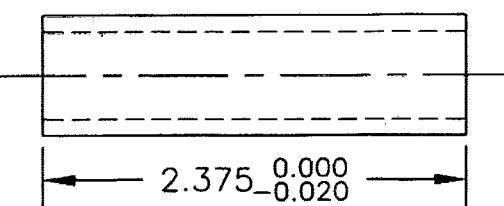
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

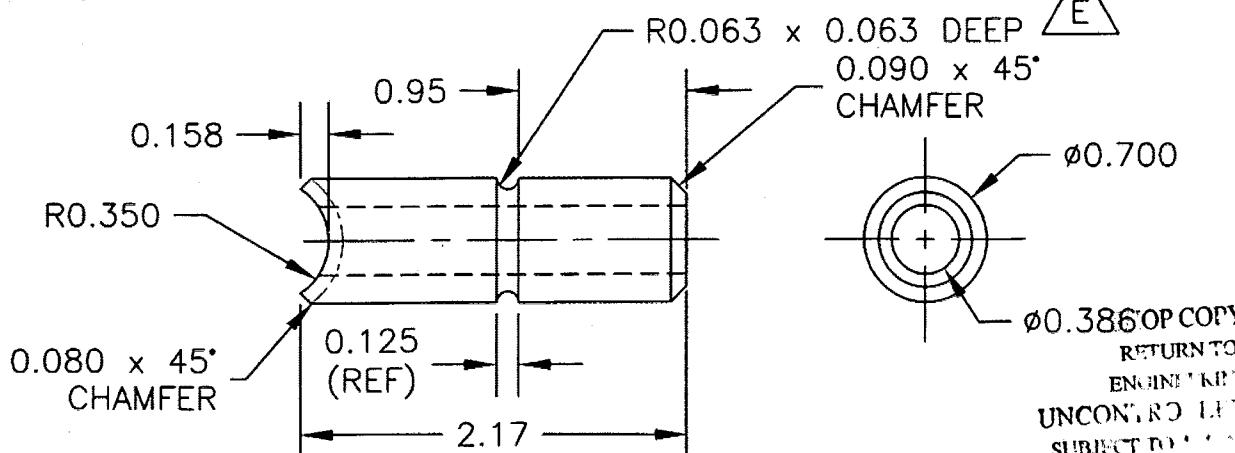
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
8/09/16

D2282-3D2282-7D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

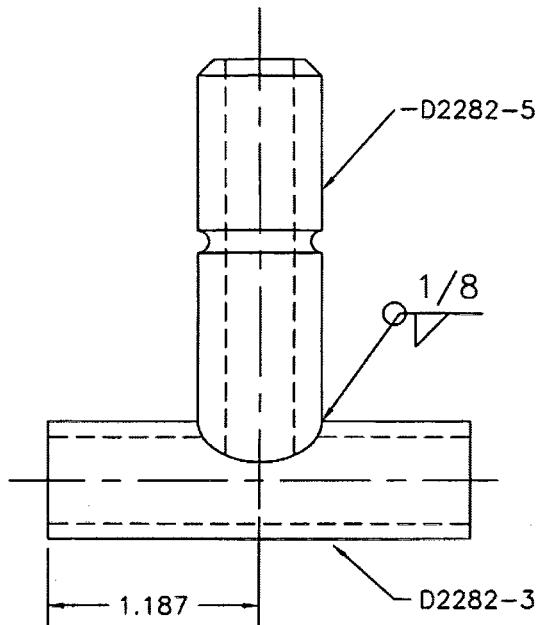
D2282-5D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

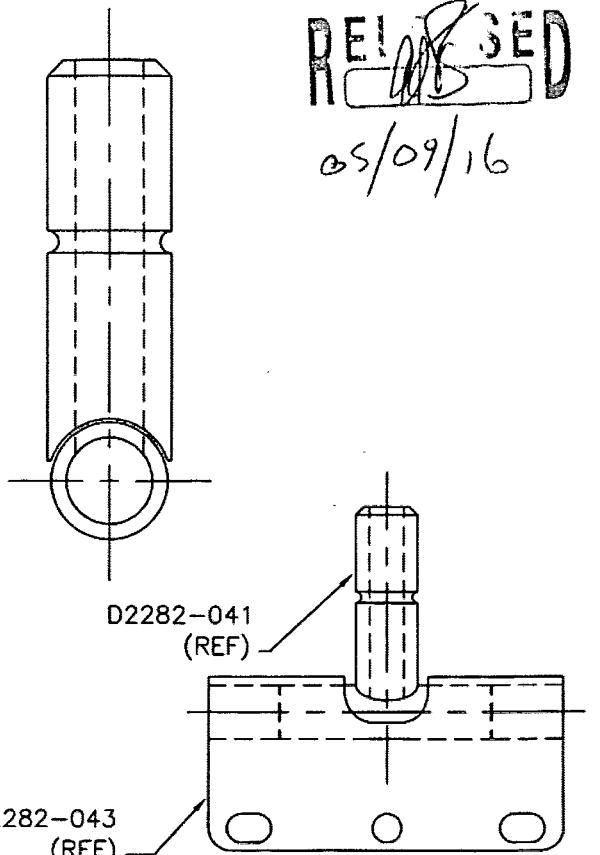


DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282
DATE 05.06.07		REV. E SHEET 2 OF 2 TITLE HANDLE TUBES SCALE 1:1



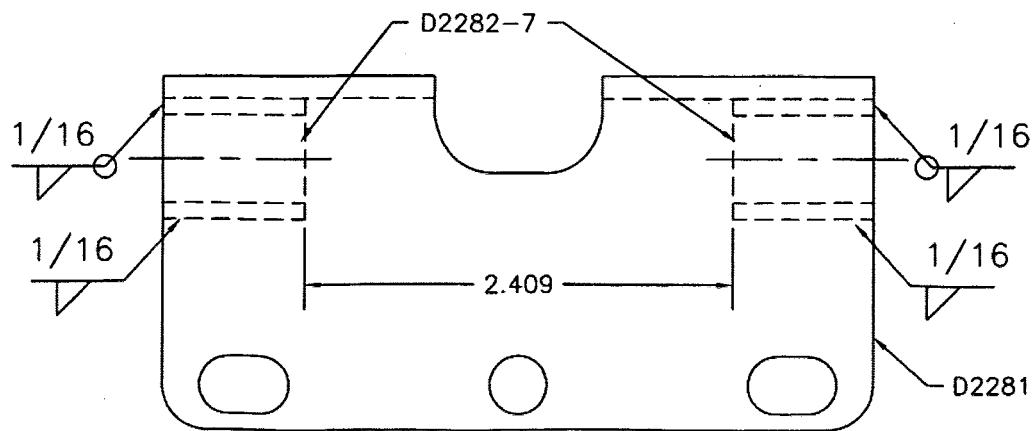
D2282-041 'T' ASSEMBLY

WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY

SCALE 1:2



D2282-043 SADDLE ASSEMBLY

WELD ASSEMBLY PER DART QSI 004

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WITHOUT NOTICE
WORK ORDER
NO. *24405B*

